

Work Order ID 72405

Monday, July 25, 2011 11:10:29 AM

SHIP JULY 29



Page 1

Item ID: D3315-1

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 7/25/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 11-07-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3315

Rev B

100



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

0.00

Handwritten signature 11/07/25

2

Memo

0.00

1-Cut as per Dwg D3315 ☒ Dwg Rev: *B* ☐ Prog Rev: *B* ☐ 2-
Deburr if necessary

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Handwritten signature 11/07/25

2

Memo

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Handwritten signature 11 07 25 (2)

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
140 	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	1- Form using DT8751 Die as per Dwg D3315Rev: <u>B</u> 2- Form using DT8179 Die and form joggle using DT8157 as per Dwg D3315Rev: <u>A</u>								
150 	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									

N/A

SB 11/07/26

2

11 07 26 23

W/O:		WORK ORDER CHANGES					
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Page 3

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Item Name: Wearplate

Start Date: 7/25/2011 Start Qty: 2.00

Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld hard surface using D3315-1T3 as per QSI 004 and Dwg D3315 Rev:

Qty Part Number Description Batch A/R

N/A

7560 Hardcoat Rod

M117137

EL 11-7-26 (2)

170

0.00



QC

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

Quality Control

DA 11.07.26 (2)

180

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

11 07 26 (2)

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Page 4

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Start Date: 7/25/2011	Start Qty: 2.00		Cust Item ID:		
Required Date: 7/26/2011	Req'd Qty: 2.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M117338</i> Memo START TIME: <i>9:00</i> <input type="checkbox"/> OVEN TEMPERATURE: <i>320</i> <input type="checkbox"/> FINISH TIME: <i>9:30</i>	0.00 0.00				<i>2</i>	<i>0</i>	<i>0</i>	<i>11-7-27</i>
200 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>2 6 11 11-7-27</i>
210 Packaging Packaging Packaging	Packaging Memo Identify on inside surface using a permanent fine point marker with the following: <input type="checkbox"/> TCCA-PDA, Dart Aerospace Ltd. <input type="checkbox"/> P/N: D3315-1, B/N: BXXXXX <input type="checkbox"/> For Product Eligibility see PDA04-17 <input type="checkbox"/> and Stock <input type="checkbox"/> Location: <i>196</i>	0.00 0.00							<i>11-7-27</i>

W/O:		WORK ORDER CHANGES					
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Page 5

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Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/7/27

11-07-27

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NOTE: Date & initial all entries

Picklist Print

Monday, July 25, 2011 11:10:34 AM

Page 1

Work Order ID: 72405



Parent Item: D3315-1



Parent Item Name: Wearplate



Start Date: 7/25/2011

Required Date: 7/26/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: A ☐ 05.05.12 ☐ New issue ☐ KJ/JLM
IPP Rev: B As per Rev B 06-03-24 JLM ☐
IPP Rev: C now water jet 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA 		Purchased	No			100	sf	150.5000	1.695	3.53125			
													

1010/1025 sheet 16GA

Location

Loc Qty

Loc Code

MAT019

150.5

116791

32.5

117500

118

4.0

11/07/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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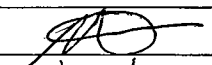
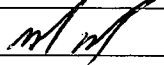
NOTE: Date & initial all entries


DART AEROSPACE LTD		Work Order:	72405
Description: Wearplate		Part Number:	D3315-1
Inspection Dwg: D3315	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.266 x 0.450	+0.006/-0.001 x +/-0.010	0.268 x 0.453	—		RA 26	Jern
4.402	+/-0.010	4.405	—		"	
4.137	+/-0.010	4.145	—		"	
3.550	+/-0.010	3.560	—		"	
5.464	+/-0.010	5.464	—		"	
5.214	+/-0.010	5.206	—		"	
1.224	+/-0.010	1.227	—		"	
2.57	+/-0.030	2.578	—		"	
6.273	+/-0.010	6.275	—		"	Jern
8.224	+/-0.010	8.231	—		RA 04	TAP
9.515	+/-0.010	9.515	—		"	
11.429	+/-0.010	11.430	—		"	
15.474	+/-0.010	15.475	—		"	
16.379	+/-0.010	16.380	—		"	
21.360	+/-0.010	21.360	—		"	
23.474	+/-0.010	23.475	—		"	
26.273	+/-0.010	26.275	—		"	
29.42	+/-0.030	29.42	—		"	
0.060	+/-0.010	0.061	—		RA 26	Jern
Ø0.300	+0.006/-0.001	0.303	—		"	"

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 11/07/25	Date: 11.07.25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.28	New Issue	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

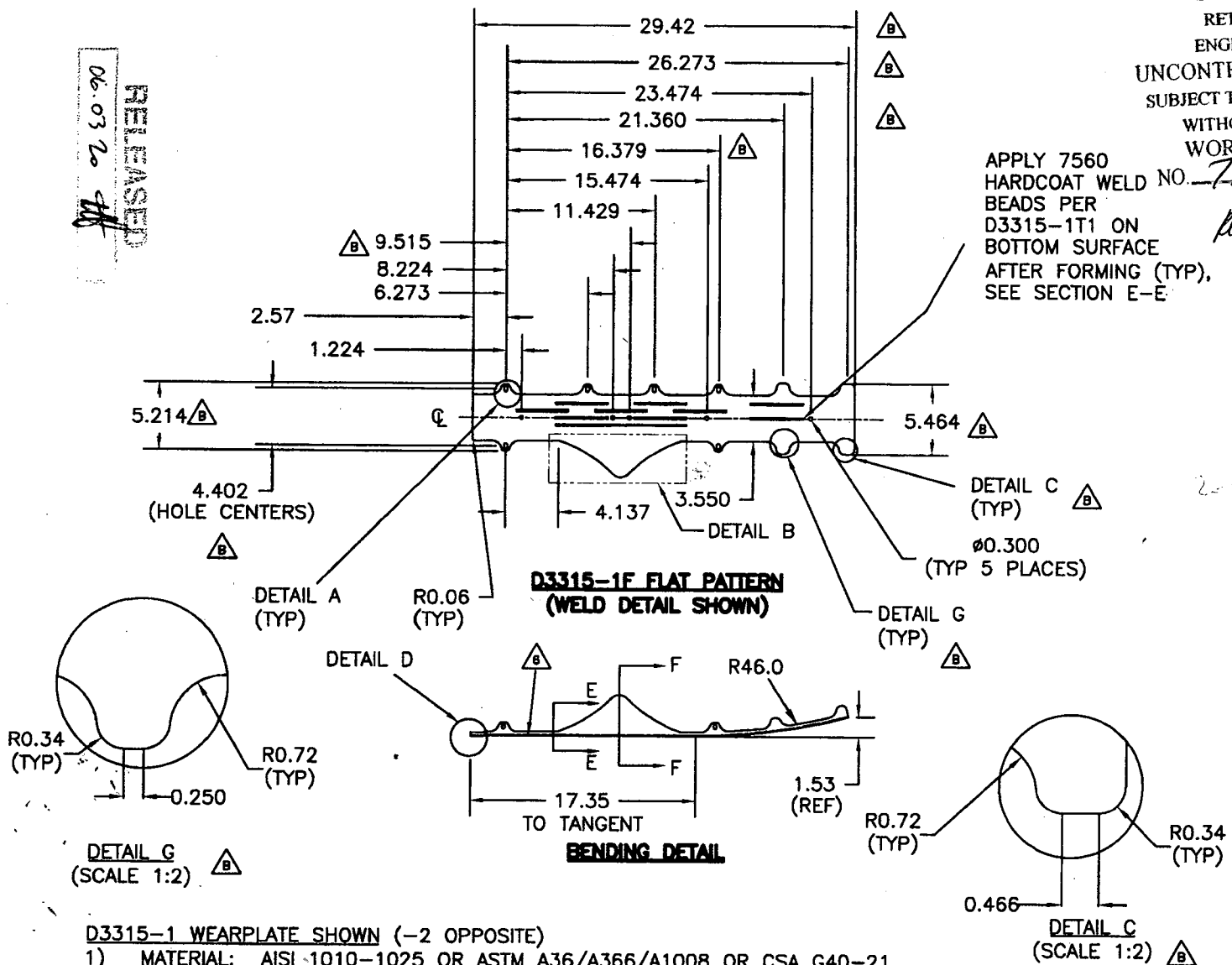
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
06.03.20



D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

APPLY 7560
HARDCOAT WELD NO. 72405
BEADS PER
D3315-1T1 ON
BOTTOM SURFACE
AFTER FORMING (TYP),
SEE SECTION E-E

11-0725

DART

DESIGN	DRAWN BY	TITLE	DART AEROSPACE LTD
04	04	D3315	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. B
06.01.31	04.09.10	WEARPLATE	SHEET 1 OF 4
A	06.01.31	NEW ISSUE	SCALE
B		UPDATE DIMENSIONS	1:12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

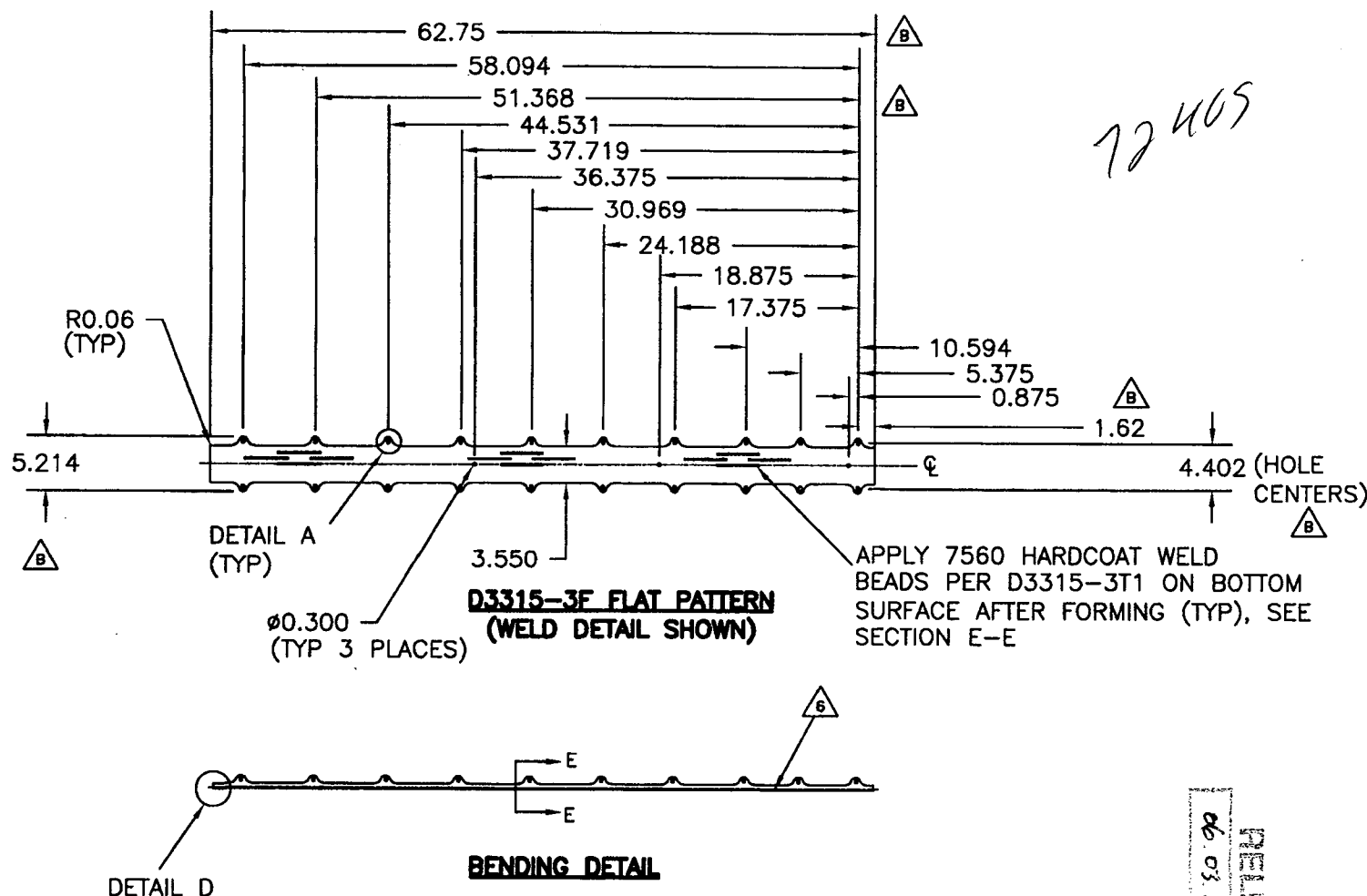
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
PH	PH	DRAWING NO.	REV. B
CHECKED	APPROVED	D3315	SHEET 2 OF 4
DATE		TITLE	SCALE
06.01.31		WEARPLATE	1:16



D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

RELEASED
26 03 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

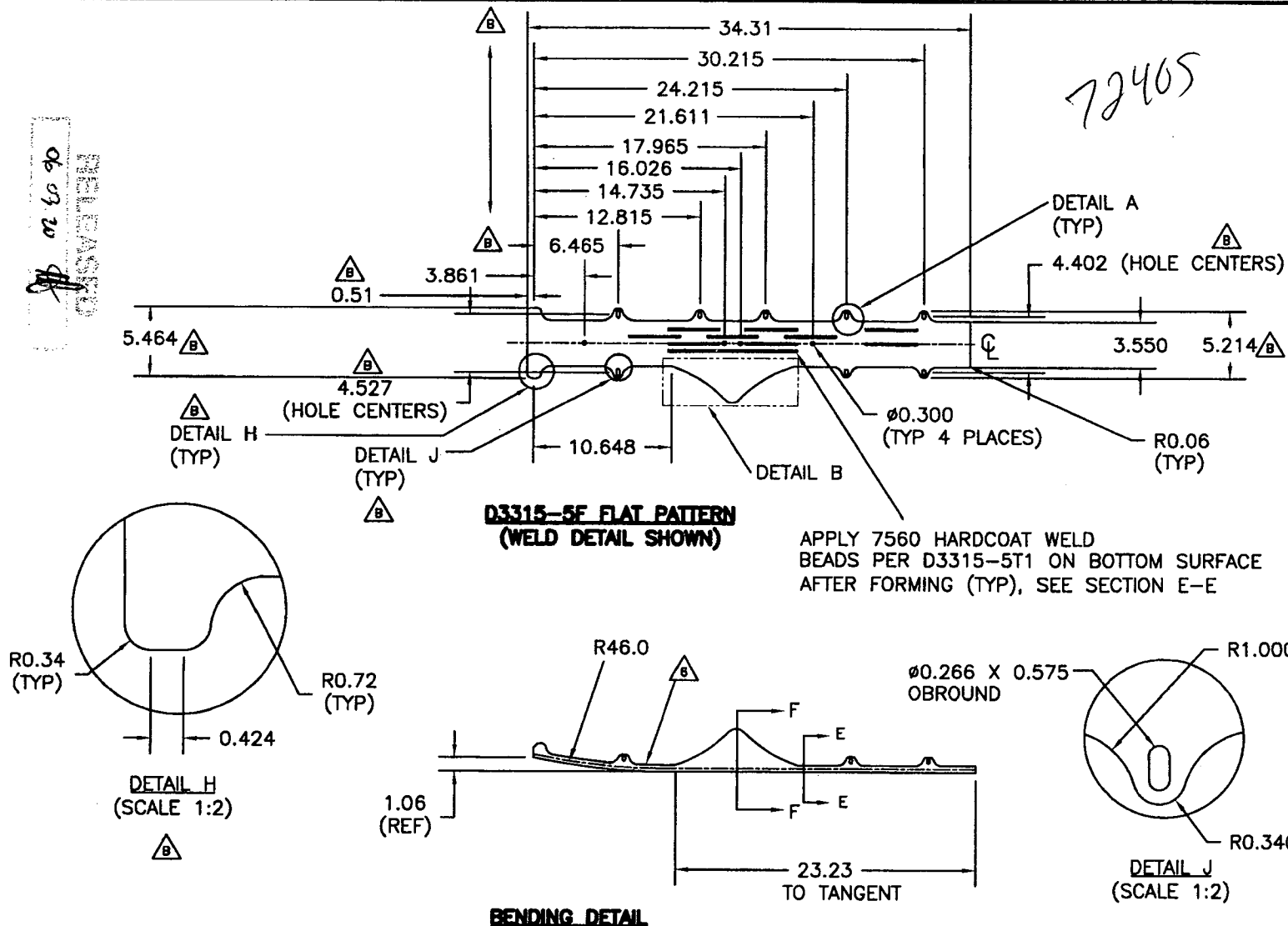
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD	
04	04	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3315	SHEET 3 OF 4
DATE	TITLE	SCALE	
06.01.31	WEARPLATE	1:12	



D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

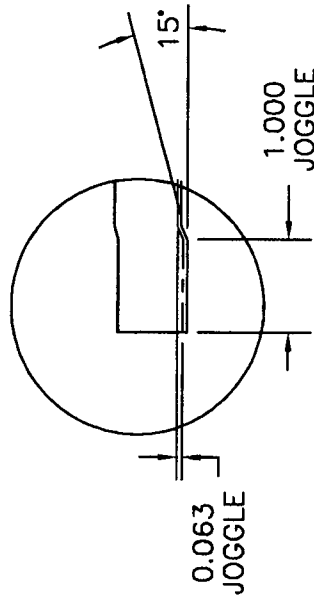
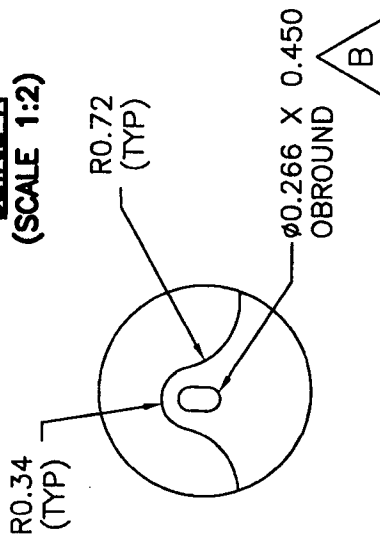
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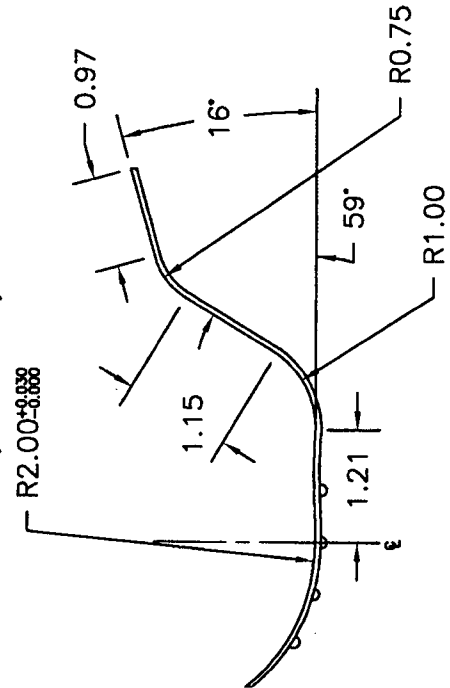
DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31	TITLE WEARPLATE		SCALE NTS

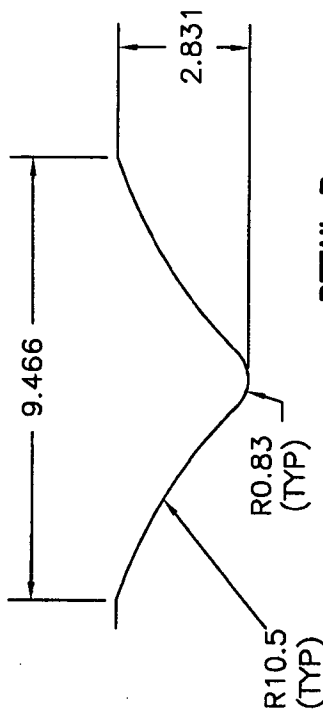
DETAIL A
(SCALE 1:2)



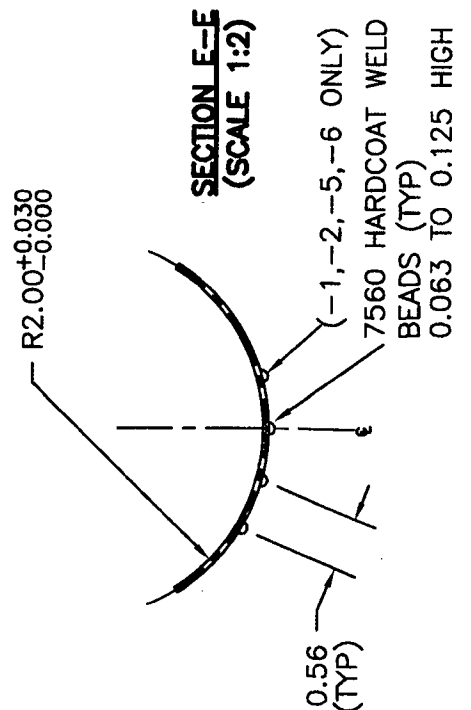
DETAIL D
(SCALE 1:2)



SECTION F-F
(SCALE 1:2)



DETAIL B
(SCALE 1:4)



SECTION E-E
(SCALE 1:2)

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